

Order 2799



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB877206-5-2
Job Sheet 176529



Part No: RB877206-5-2

Job Qty: 1 ea

Part Name: Bearing Cutter Tool Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/18

Job Tracking No: disassembly

Due Date: 4/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RB877206-5 REV 4A 1PP REV A 18.02.22 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/30/18	0.00	0.00	Start Up Small Fab-2		
110	Rework	1 pcs		4/30/18	0.00	0.00	Mill Conv 1		
120	QC	1 pcs		4/30/18	0.00	0.00	QC5		PD 18-04-28
130	Packaging	1 pcs		4/30/18	0.00	0.00	Packaging3-1		83
140	QC21-FG	1 Ea		4/30/18	0.00	0.00	QC21		DAS

Part Op
Descriptions: **130** - Bag and Tag

21 APR 27 2018
3-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB877206-18-2	Bearing Cutting Tool Assembly	1 pcs (1 ea)	90-Start up Operation	S065043

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB877206-18-2	1	2	0

Part Specifications

Specifications could not be found.

WD - DISASSEMBLE TOOL AND DISCARD - 9
Bushing.
- SPOT FACE & ENGRAVE RB877206-5-2
- Re-Assemble.
Final 18-04-25



Container No: S065043



Part: RB877206-5-2

Job No: 176529

Serial No/Batch: S065043

Revision: 4A

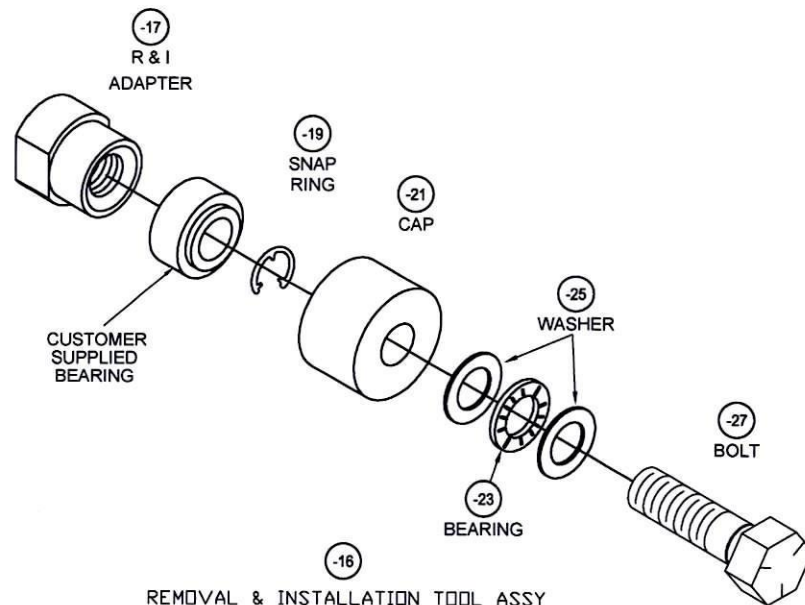
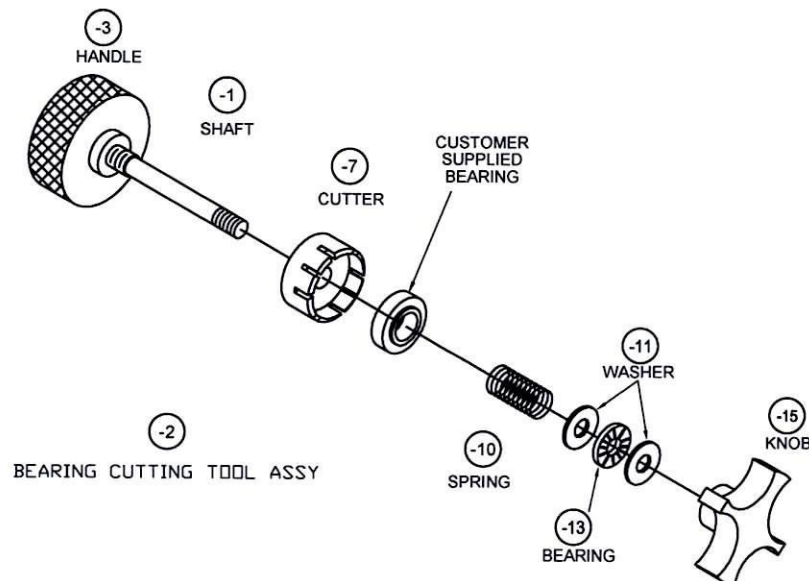
Inspector:

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Hawkesbury, ON K6A 1K7
CANADA
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Date: 04/25/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2' TO 5' TO IMPROVE OPERATION.	2/19/04	
2	CH'D -7 PREGRIND TOLERANCE FROM .953.	1/2/08	WP G.E.
3	ADDED AN 8' HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP DW
4	CH'D -27 GROOVE NOMENCLATURE FROM .032 W x .025 DP.	1/29/08	WP GE
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC RW



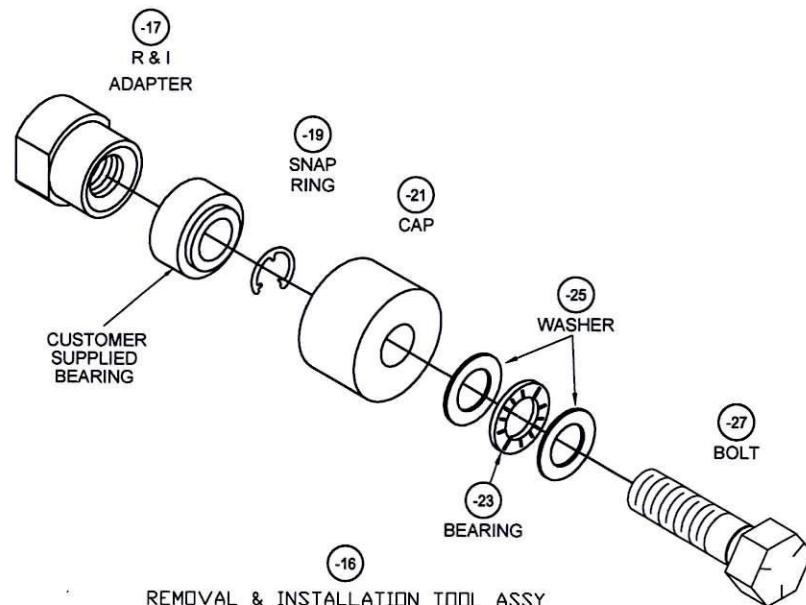
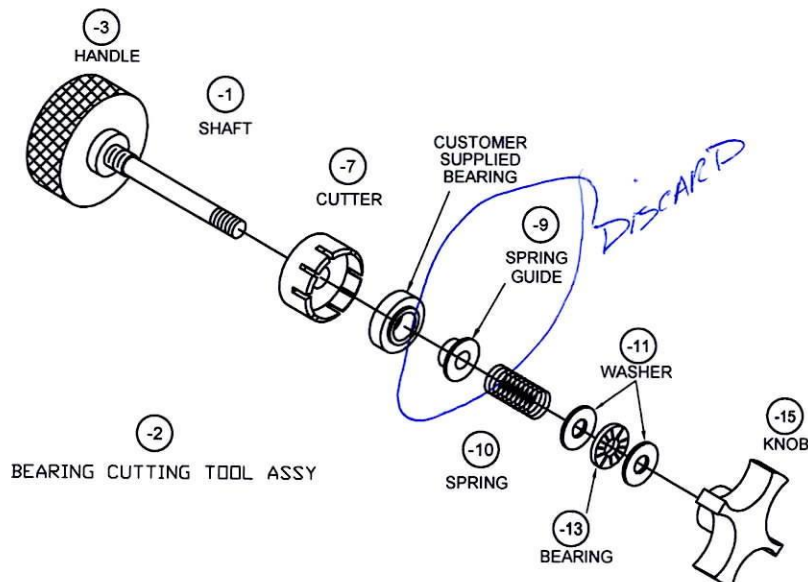
NOTE:
BEARING #206-010-469-001, 206-010-470-001, ASTRO AM2004DHS

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1 x 5/8	3
	1	B/O	-10		SPRING		5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER		TRA-512 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING		NTA512 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB		DK-55 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1-1/4 x 1-1/4	4
	1	B/O	-19		SNAP RING		Ø5/16 EXTERNAL	1
	1		-21		CAP	6061 T6	Ø1-1/2 x 1	4
	1	B/O	-23		BEARING		NTA512 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER		TRA-512 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	5/16-24 UNF x 3 MODIFY	4
ASSY QTY	ASSY QTY							
-16	-2							

RED BARN MACHINE TITLE BEARING CUTTER		DWG NO.	RB877206-5	REV	4A
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° X ± .1 UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
DRAWN BY: COLE APPROVED: <i>D. Med</i> HEAT TREAT FINISH SPEC USED ON MODEL BELL		SCALE	NTS	DATE	6-28-01
		SHEET	1 of 4		

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04	
2	CH'D -27 GROOVE FOR RETAINING RING.	9/21/06	
3	CH'D -7 PREGRIND TOLERANCE FROM .940 +.005 -.002.	1/2/08	WP G.E.
4	ADDED AN 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP DW
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC RW



NOTE:
BEARING #206-031-594-003, ASTRO NHW7V203 J/N 39034-2 AD

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1 x 5/8	3
	1		-9		SPRING GUIDE	STRESS PROOF	Ø5/8 x 5/16	3
	1	B/O	-10		SPRING	-	5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER	-	TRA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING	-	NTA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB	-	DK-54 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1 x 1-1/4	4
	1	B/O	-19		RETAINING RING	-	Ø3/8 EXTERNAL E-37	1
	1		-21		CAP	6061 T6	Ø1-1/4 x 1	4
	1	B/O	-23		BEARING	-	NTA-613 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER	-	TRA-613 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	7/16-20 UNF x 2-1/2 MODIFY	4

ASSY QTY	ASSY QTY	SCALE	DATE	SHEET
-16	-2	NTS	6-28-01	1 of 4

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-18	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL BELL	